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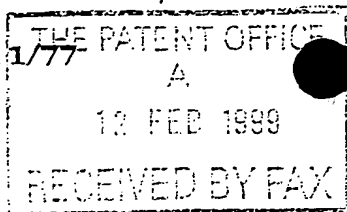
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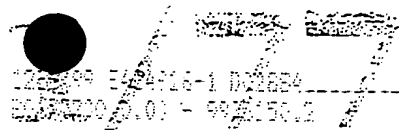
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Patents ADP number (if you know it)

If the applicant is a corporate body, give the country/state of its incorporation

007 687 56002
United Kingdom

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4. Title of the invention

"Apparatus for Swaging an Object"

5. Name of your agent (if you have one)

Murgitroyd & Company

"Address for service" in the United Kingdom to which all correspondence should be sent (including the postcode)

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1 "Apparatus for Swaging an Object"

2
3 The present invention relates to an apparatus for
4 swaging an object, and particularly relates to an
5 apparatus for swaging an end of a tubular member, such
6 as a length of casing or drillpipe used in the oil and
7 gas industry.

8
9 Conventionally, casing tubulars have a standard pin
10 type connector at each end, and one end of a casing
11 tubular is connected to an end of another casing
12 tubular by means of a casing joint, commonly known as a
13 coupler, and which comprises a short length of tube
14 having a standard box type connector at each end.
15 Alternatively, tubulars, such as drill pipe in
16 particular, have a standard pin type connection at one
17 end and a standard box type connection at the other
18 end.

19
20 It is important that a made up tubular string, such as
21 a casing, lining or drill string has a substantially
22 linear throughbore at the joints between the respective
23 tubulars, and couplers if present.

24
25 The pin and/or box connections are conventionally made

2

up on a tubular by first swaging respectively inwardly or outwardly the outer diameter of the ends of the pipe by a suitable amount so that pins can be formed. This swaging of the outer diameter of the pipe necessarily respectively reduces or increases the internal diameter of the pipe end.

After the end of the pipe has been swaged, the internal or external diameter of the end of the pipe is then machined. The swaging process ensures that there is material around the entire circumference of the internal or external diameter of the pipe that can be machined away, thereby achieving concentricity of the internal or external diameter of the pipe end. Additionally, this ensures that there are no thick or thin sections of wall thickness on the pipe end, thereby ensuring a constant wall thickness to the pipe end.

Thereafter, the screw thread of the pipe end can be formed on its outer or inner circumference.

A conventional machine for swaging an end of a pipe comprises a swaging head having a single swaging formation thereon for swaging a particular diameter of pipe. The pipe to be swaged is held between a semi-circular lower clamp and two upper quarter circular segments, where the two upper segments are hinged to the lower semi-circular clamp to permit the pipe to be inserted into the clamp. The clamp is provided with plurality of teeth, in a saw tooth arrangement, to grip the pipe. However, with the saw tooth arrangement, the teeth tend to bite into and damage the outer wall of the pipe. Furthermore, where the pipe has slight variations in the outer circumference of its wall, the teeth will tend to grip certain parts of the outer

1 diameter more forcefully than other parts, since the
2 clamping device is substantially immovable once it has
3 been closed.

4
5 According to a first aspect of the present invention,
6 there is provided an apparatus for swaging an end of a
7 tubular, the apparatus comprising a swaging head for
8 providing the swage to the end of the tubular, wherein
9 the swaging head has two or more swaging formations
10 provided thereon to permit swaging of differing
11 diameters of tubular ends.

12
13 The swaging formation may be provided on an internal
14 bore of the swaging head, such that the internal bore
15 of the swaging head engages the outer diameter of the
16 tubular end to provide the swage thereto.

17
18 Each swaging formation may comprise a first diameter of
19 the swaging head, a second diameter being smaller than
20 the first diameter, a third diameter being smaller than
21 the second diameter, and a fourth diameter being
22 smaller than the third diameter. Preferably, the
23 internal bore of the swaging head tapers substantially
24 linearly inwardly, with respect to the longitudinal
25 axis of the swaging head, from the first diameter to
26 the second diameter, and from the second diameter to
27 the third diameter. Typically, the angle of the taper
28 from the first to the second diameter is greater than
29 the angle of the taper from the second to third
30 diameter. Typically, the surface of the internal bore
31 of the swaging head provided by the taper from the
32 first to the second diameter is a guiding surface, and
33 the surface provided by the taper from the second to
34 third diameter is a swaging surface.

35
36 The surface of the internal bore of the swaging head

4

1 from the second/third diameter to the third/fourth
2 diameter may be arranged to be substantially
3 perpendicular to the longitudinal axis of the swaging
4 head, and is preferably arranged to provide a shoulder
5 or a stop surface against which the tubular end
6 arrests.

7
8 Preferably, the swaging head is arranged with at least
9 first and second swaging formations, whereby the fourth
10 diameter of the first swaging formation is greater than
11 the first diameter of the second swaging formation.
12 Typically, the first diameter of the first swaging
13 formation is the closest diameter of all of the
14 diameters of all of the swaging formations to the
15 tubular end, in use.

16
17 Alternatively, the swaging formation may be provided on
18 an external diameter of the swaging head, such that the
19 external diameter of the swaging head engages the inner
20 diameter of the tubular end to provide the swage
21 thereto.

22
23 Each swaging formation may comprise a first diameter of
24 the swaging head, a second diameter being greater than
25 the first diameter, a third diameter being greater than
26 the second diameter, and a fourth diameter being
27 greater than the third diameter. Preferably, the
28 external diameter of the swaging head tapers
29 substantially linearly outwardly, with respect to the
30 longitudinal axis of the swaging head, from the first
31 diameter to the second diameter, and from the second
32 diameter to the third diameter. Typically, the angle
33 of the taper from the first to the second diameter is
34 greater than the angle of the taper from the second to
35 third diameter. Typically, the surface of the external
36 diameter of the swaging head provided by the taper from

5

1 the first to the second diameter is a guiding surface,
2 and the surface provided by the taper from the second
3 to third diameter is a swaging surface.

4
5 The surface of the external diameter of the swaging
6 head from the second/third diameter to the third/fourth
7 diameter may be arranged to be substantially
8 perpendicular to the longitudinal axis of the swaging
9 head, and is preferably arranged to provide a shoulder
10 or a stop surface against which the tubular end
11 arrests.

12
13 Preferably, the swaging head is arranged with at least
14 first and second swaging formations, whereby the fourth
15 diameter of the first swaging formation is smaller than
16 the first diameter of the second swaging formation.
17 Typically, the first diameter of the first swaging
18 formation is the closest diameter of all of the
19 diameters of all of the swaging formations to the
20 tubular end, in use.

21
22 Two or more swaging formations may be provided.

23
24 According to a second aspect of the present invention,
25 there is provided an apparatus for swaging an end of a
26 tubular, the apparatus comprising a swaging head for
27 swaging the end of the tubular, and a stop plate for
28 abutment against the other end of the tubular, the
29 swaging head and the stop plate being movably coupled
30 to one another.

31
32 Movement of the swaging head and the stop plate toward
33 one another typically facilitates swaging of the said
34 one end of the tubular.

35
36 Typically, the swaging head is moveable toward the stop

6

1 plate by means of a piston, and preferably, the swaging
2 head and the stop plate are movably coupled to one
3 another by a frame. Typically, the frame is adjustable
4 such that distance between the stop plate and the
5 swaging head can be further varied by adjustment of the
6 frame.

7
8 Typically, the frame comprising at least one member
9 coupled to both of the swaging head and the stop plate,
10 and preferably the coupling between the member and at
11 least one of the stop plate and swaging head can be
12 adjusted in order to vary the length of the member
13 between the swaging head and the stop plate.
14 Preferably, the coupling between the member and the
15 stop plate is in the form of a screw thread engagement.

16
17 Preferably, the stop plate comprises a bore and a
18 device for obturating the bore, such that when the
19 device obturates the bore, the device abuts the said
20 other end of the tubular. Typically, the device is
21 removable from the stop plate such that a tubular to be
22 swaged may be passed through the bore. This provides
23 the invention with the advantage that the device can be
24 inserted into or over the bore so that short lengths of
25 tubular can be swaged, and the device can be removed
26 from the stop plate so that longer lengths of tubular
27 can be swaged.

28
29 According to a third aspect of the present invention
30 provides an apparatus for swaging an end of a tubular,
31 the apparatus comprising a swaging head for swaging the
32 end of the tubular, and a clamping device for clamping
33 the tubular, the clamping device being split into at
34 least three part-circular clamping segments which clamp
35 substantially around the outer circumference of the
36 tubular to permit it to be swaged.

1 Preferably, there are at least four part-circular
2 clamping segments which clamp substantially around the
3 outer circumference of the tubular to permit it to be
4 swaged.

5
6 Preferably, there are two clamping devices provided,
7 typically a forward clamping device which is arranged
8 to be closest to the swaging head, and a rear clamping
9 device which is arranged to be furthest from the
10 swaging head.

11
12 Typically, the clamping segments are housed within a
13 clamping ring, and may be mounted on the clamping ring
14 in an arrangement such that the segments can move,
15 preferably only to be a relatively small degree, with
16 respect to the ring.

17
18 Preferably, the clamping ring is split into at least
19 two part circular members, where the members may be
20 hinged together, such that the ring may be opened to
21 permit a tubular to be inserted into the ring, and
22 closed to clamp the segments around the tubular.

23
24 Typically, a range of segments can be housed within the
25 ring, where the range of segments may be of varying
26 radial thickness, to permit a range of differing
27 diameter tubulars to be clamped.

28
29 According to a fourth aspect, the present invention
30 provides an apparatus for swaging a tubular, the
31 apparatus comprising a swaging head for swaging the end
32 of the tubular, and a clamping device for clamping the
33 tubular, the clamping device having a plurality of
34 teeth for gripping the outer surface of the tubular,
35 and a plurality of grooves formed between the teeth,
36 wherein the gripping surface of each tooth is

1 substantially parallel to the longitudinal axis of the
2 tubular to be gripped.

3
4 This provides the invention with the advantage that the
5 teeth do not bite into the outer surface of the
6 tubular, thus avoiding damaging the tubular.

7
8 The grooves may be formed with two side walls which are
9 substantially perpendicular to the longitudinal axis of
10 the tubular to be gripped, and may be formed with a
11 lowermost surface which is substantially parallel to
12 the longitudinal axis of the tubular to be gripped.

13
14 An embodiment of the present invention will now be
15 described, by way of example only, with reference to
16 the accompanying drawings, in which:-

17
18 Fig. 1 is a side view of an apparatus for swaging
19 an end of a tubular in accordance with the present
20 invention;

21 Fig. 2 is a plan view of the apparatus of Fig. 1;
22 Fig. 3 is an end view of the apparatus of Fig. 1;
23 Fig. 4 is an end view of the clamping device of
24 the apparatus of Fig. 1;

25 Fig. 5 is a plan view of the clamping device of
26 Fig. 4;

27 Fig. 6 is a cross-sectional view of a first
28 swaging head for use of the apparatus of Fig. 1;

29 Fig. 7 is a second swaging head for use with the
30 apparatus of Fig. 1;

31 Fig. 8 is a third swaging head for use with the
32 apparatus of Fig. 1;

33 Fig. 9 is a fourth swaging head for use with the
34 apparatus of Fig. 1;

35 Fig. 10 is a series of part cross-sectional side
36 views of gripping devices for use with the

1 clamping device of Fig. 4;
2 Fig. 11 is an end view of one of the sets of
3 gripping devices of Fig. 10;
4 Fig. 12 is a part cross-sectional side view of the
5 set of gripping devices of Fig. 11;
6 Fig. 13 is a detailed cross-sectional view of a
7 portion of the gripping device of Fig. 12;
8 Fig. 14 is a side view of a first male swaging
9 head for use of the apparatus of Fig. 1;
10 Fig. 15 is a second male swaging head for use with
11 the apparatus of Fig. 1;
12 Fig. 16 is a third male swaging head for use with
13 the apparatus of Fig. 1; and
14 Fig. 17 is a fourth male swaging head for use with
15 the apparatus of Fig. 1.

16
17 Fig. 1 shows an apparatus for swaging the end of a
18 tubular or a pipe such as a length of casing or
19 drillpipe used in the oil and gas industry.

20
21 The apparatus comprises a base frame 1 which, in use of
22 the apparatus, would typically lie on a workshop floor.
23 A press head 3 is mounted on the base frame 1 by means
24 of a cap screw 12 and taper washer 13, such that the
25 press head 3 stands vertically upright from the
26 horizontally arranged base frame 1. A swaging cylinder
27 2 is mounted on the press head 3 by means of a
28 plurality of cap screws 14, such that the longitudinal
29 axis of the swaging cylinder 2 is arranged to be
30 substantially horizontal. A piston rod 18 is located
31 within the swaging cylinder 2, such that the piston rod
32 18 lies on the longitudinal axis of the swaging
33 cylinder 2. The furthest end of the piston rod 18 is
34 typically coupled to a swaging or die head 17 by means
35 of a cap screw 11, such that actuation of the swaging
36 cylinder 2 moves the piston rod 18, and hence die head

10

1 17 outwardly from the swaging cylinder 2, until the
2 piston rod 18 has potentially travelled its maximum
3 stroke or contact is made with the stop shoulder, which
4 is indicated in Fig. 1 by the die heads 17 reaching its
5 position which is shown in phantom 17A. As shown in
6 Fig. 1, it is preferred that the maximum stroke of the
7 piston rod 18, and hence die head 17, is twelve inches.

8
9
10 A clamping unit 4 is mounted on the base frame 1 at
11 approximately the mid-point of the base frame 1, such
12 that the clamping unit stands vertically upright with
13 respect to the base frame 1. The clamping unit 4 will
14 be described in more detail subsequently.

15
16 An end stop 5 is movably mounted upon the base frame 1,
17 such that the end stop 5 stands vertically upright with
18 respect to the base frame 1.

19
20 A first pair of struts or strengthening members in the
21 form of tie rods 6 are provided between the press head
22 3 and the clamping unit 4, and are arranged to lie on
23 the plane of the longitudinal axis of the swaging
24 cylinder 2, on either side of the die head 17. The tie
25 rods 6 are secured to the press head 3 by means of nuts
26 8, and are screw threaded to the clamping unit 4. A
27 second pair of struts or strengthening members in the
28 form of tie rods 7 act between the clamping unit 4 and
29 the end stop 5, and are arranged to lie on the plane of
30 the longitudinal axis of the swaging cylinder 2. The
31 tie rods 7 are secured to the clamping unit 4 by means
32 of screw threads, and are secured to the end stop 5 by
33 means of a nut 19 on one side of the end stop 5, and a
34 hand wheel nut 15 on the other side of the end stop 5.
35 It should be noted that the majority of the outer
36 surface of the tie rods 7 is provided with a screw

11

1 thread formation thereon, such that an operator of the
2 apparatus can rotate the hand wheel nut 15 to permit
3 the end stop 5 to be moved along the tie rods 7 from
4 the position of the end stop 5 shown in Fig. 1 to the
5 position of the end stop 5A shown in phantom in Figs. 1
6 and 2. Thus, the distance between the end stop 5 and
7 the die head 17 can be varied.

8
9 As shown in Fig. 2, the end stop 5 is provided with a
10 bore 20, which can be obturated by placing a push plate
11 9 on the end stop 5, and attaching the push plate 9 by
12 means of a stud 13, nuts 16 and a retaining plate 21.

13
14 Accordingly, the push plate 9 can be placed on the end
15 stop 5, as shown in Figs. 1 and 2, and the end stop 5
16 can be positioned so that the push plate 9 butts
17 against an end of a relatively short length of pipe,
18 such as a pup joint 22 used in the oil and gas
19 industry. The middle of the pup joint 22 can be
20 supported by the clamping unit 4, and the swaging
21 cylinder 2 can be operated to move the die head 17
22 toward the closest end of the pup joint 22 to it, such
23 that the die head 17 swages the end of the pup joint
24 22.

25
26 As shown in Fig. 4, the clamping unit 4 comprises a
27 clamp base 41, and a pair of clamp arms 42, 43 which
28 are respectively hingedly coupled to the clamp base 41
29 by means of pivot pins 44, washers 51 and split pins 52
30 at the lowest ends of the respective clamp arms 42, 43.
31 The upper ends of the clamp arms 42, 43 can be
32 releasably coupled together by means of a cylinder 45
33 which is attached to one of the clamp arms 43 by means
34 of a trunnion bearing half 46 and a socket head cap
35 screw 47. A trunnion pin 48 is mounted on the other
36 clamp arm 42 by means of a washer 49 and split pin 50,

12

1 and the trunnion pin 48 is engageable with the trunnion
2 bearing half 46, such that operation of the cylinder 45
3 pulls the clamp arms 42, 43 toward one another.
4 However, it should be noted that the connection between
5 the arms 42, 43 can be varied so as to make them
6 interchangeable, for ease of production.

7
8 Thus, the clamp arms 42A, 43A are moveable from their
9 open position shown in phantom on Fig. 4 in which a
10 pipe (not shown) can be inserted into the clamp unit 4,
11 to a closed position 42, 43 in which the clamping arms
12 42, 43 substantially surround a section of the outer
13 circumference of the tubular.

14
15 A first example of a "female" die head 17A is shown in
16 Fig. 6, where this die head 17A is suitable for swaging
17 two different pipe sizes, these being a relatively
18 large pipe size of $13\frac{3}{8}$ inches outer diameter, and a
19 smaller pipe having an outer diameter of $10\frac{3}{4}$ inch.
20 However, it should be noted that the specific
21 dimensions of the diehead can be varied for different
22 swaging requirements.

23
24 This example of the die head 17A has a first swaging
25 formation, generally designated as 22A, and is formed
26 on the internal bore of the die head 17A. This first
27 swaging formation 22A has a first diameter 23A formed
28 at the mouth of the internal bore of the die head 17A.
29 A second diameter 24A is shown as being to the right of
30 the first diameter 23A in Fig. 6, where the second
31 diameter 24A is slightly smaller than the first
32 diameter 23A (13.86 inches). The surface of the
33 internal bore tapers linearly inwards from the first
34 23A to the second 24A diameters at an angle of 9° to
35 the longitudinal axis of the die head 17, and forms a
36 lead-in surface 25A to guide the pipe end into the

13

1 internal bore of the die head 17. A third diameter 26A
2 is shown in Fig. 6 as being to the right of the second
3 diameter 24A, where the third diameter 26A is smaller
4 (13.24 inches) than the second diameter 24A. The
5 surface of the internal bore tapers linearly inwardly
6 from the second 24A to the third 26A diameters at an
7 angle of 3° to the longitudinal axis of the die head
8 17, where the surface between the second 24A and third
9 26A diameters forms a swaging surface 27A to provide a
10 swage to the 13³/₈ inch pipe end. A shoulder 28A
11 projects radially inwardly at an angle perpendicular to
12 the longitudinal axis of the die head 17 and provides a
13 stop surface thereon to ensure that the die heads 17
14 cannot "overswage" the pipe end.

15
16 A second swaging formation 22B is also provided on the
17 internal bore of the die heads 17, and is shown in Fig.
18 6 as being to the right of the first swaging formation
19 22A. The various diameters 23B, 24B, 26B of the second
20 swaging formation 22B are all smaller than the
21 respective diameters 23A, 24A, 26A of the first swaging
22 formation 22A, and are of a size suitable for providing
23 a swage to a 10³/₄ inch pipe.

24
25 Fig. 7 shows a second example of a die head 17B, and
26 which has a first swaging formation 22C, which is
27 similar to the first swaging formation 22A of the die
28 head 17A, and a similar second swaging formation 22D.
29 The swaging formations 22C, 22D are sized to provide a
30 swage to respective pipe sizes 9⁵/₈ inch and 7⁵/₈ inch.

31
32 Fig. 8 shows a third example of the die head 17C, where
33 this die head 17C has three swaging formations 22E,
34 22F, 22G provided thereon to enable the die head 17C to
35 provide a swage to three different pipe sizes, these
36 being respectively 7 inch, 5¹/₂ inch and 4¹/₂ inch.

14

1 Fig. 9 shows a fourth example of a die head 17D, also
2 having three swaging formations 22H, 22I, 22J provided
3 thereon to enable the die head 17D to provide a swage
4 to three different pipe sizes, these being respectively
5 $6\frac{5}{8}$ inch, 5 inch and 4 inch pipe diameters.

6
7 An operator of the apparatus can choose the correct die
8 head 17A, B, C, D as required by the diameter of the
9 pipe, and can attach the correct die head 17A, B, C, D
10 by means of the cap screw 11.

11
12 It will also be appreciated by those skilled in the art
13 that a die head having one or more swaging formations
14 formed on it's outer circumference for providing a
15 swage to the inner bore of an end of a tubular can also
16 be provided for use with the apparatus, and such a
17 range of "male" dieheads is shown in Figs. 14 to 17.
18 The one or more swaging formations on the outer
19 circumference are, in essence, mirror images of the
20 swaging formations hereinbefore described in detail.

21
22 Figs. 11 and 12 show one set of clamping segments or
23 collets 30A, B, C, D where each clamping collet 30
24 circumscribes an angle of preferably slightly less than
25 90° of a circle. However, it should be noted that two
26 sets of clamping collets 30, 32 are utilised in the
27 apparatus, as will now be described. As shown in Fig.
28 10, a forward set 30 of collets is mounted to the
29 clamping unit 4, where this first set 30 is arranged to
30 be closest to the die head 17, and a rear set 32 of
31 clamping collets is also mounted to the clamping unit
32 4. The two lower clamping collets 30B, 30C are mounted
33 to the lower semi-circular bore of the clamp base 41,
34 and one of the upper clamping collets 30A, 30B are
35 mounted to the respective clamp arms 42, 43, where each
36 clamping collet 30A, B, C, D is mounted to the clamping

15

1 units by means of a fixing screw 33 which passes
2 through a first aperture 34 in the respective clamping
3 collet 30A, B, C, D. Thus, since there is only one
4 fixing screw 33 per clamping collet, the clamping
5 collets 30 can move slightly with respect to the
6 clamping unit 4, and this provides the apparatus with
7 the advantage that the clamping collets can move to
8 compensate for slight irregularities in the outer
9 circumference of the pipe to be swaged.

10

11 However, the two lower clamping collets 30B, 30C may be
12 modified to be combined into one lower clamping collet
13 (not shown) which would preferably circumscribe an
14 angle of slightly less than 180° of a circle. This
15 modified lower clamping collet is also preferably
16 mounted on the clamping unit in a suitable arrangement
17 such that it can move slightly with respect to the
18 clamping unit 4.

19

20 The inner bore of the clamping collets 30 is provided
21 with a clamping formation thereon, as shown in Fig. 13.
22 The clamping formation comprises a plurality of flat
23 teeth 35 which are of equal width. The upper surface
24 of the flat teeth 35 are parallel with the longitudinal
25 axis of the pipe to be swaged, and the flat teeth 35
26 are spaced apart by substantially flat troughs 36,
27 where the flat troughs 36 are of substantially equal
28 length with the flat teeth 35. In the clamping collets
29 30 shown in Fig. 13, there are six flat teeth 35 per
30 inch along the internal surface of the clamping collets
31 30. The presence of the flat troughs 36 provide the
32 advantage that corrosion or contamination appearing on
33 the outer surface of the pipe to be swaged can be
34 squeezed off by the flat teeth 35 and located within
35 the flat troughs 36, thus providing an enhanced
36 clamping action upon the pipe to be swaged.

1 Furthermore, the flat teeth 35 do not "bite" into the
2 outer surface of the pipe to be swaged.

3
4 As shown in Fig. 10, there are ten arrangements of sets
5 of clamping collets for clamping ten different
6 diameters of pipe, although there may be additional
7 sets provided for non-standard diameter pipes. The
8 first set, as shown in set (1), is for clamping around
9 the largest casing diameter normally used, this being
10 13.38 inches. Set (2) and set (3) are for clamping
11 10.75 inches and 9.63 inches diameter pipes
12 respectively, with clamping collets 56 and 57
13 respectively. The clamping collets 57 of set (3) can
14 be combined with different radius collet inserts 58A,
15 B, C, D, E, F, G by means of fixing screws 59 to permit
16 smaller diameter pipe sizes 7.62 inches, 7 inches, 6.62
17 inches, 5.5 inches, 5 inches, 4.5 inches and 4 inches
18 respectively to be clamped. Thus, by combining the
19 collet inserts 58A-G with the clamping collets 57, the
20 apparatus has the advantage of providing a flexible
21 arrangement for clamping and thereafter swaging a
22 variety of different diameter pipe sizes.

23
24 As stated before, the push plate 9 can be located on
25 the end stop 5 to permit short lengths of pipe such as
26 pup joints 22 to be swaged; clamping unit 4 is not used
27 in this case and the two lower clamping collets 30B,
28 30C support the pup joint 22 at its mid point. For
29 longer lengths of pipe, the push plate 9 is removed,
30 and the pipe end to be swaged is passed through the
31 bore 20 of the end stop 5, and the clamp arms 42, 43
32 are closed around the outer diameter of the pipe.

33
34 The die head 17 is typically pushed onto the end of the
35 pipe to be swaged, with typically 350 tonnes of push
36 being applied. With this amount of push being applied,

17

1 a shoulder 60 is provided on the clamping collets 30,
2 32, 56, 57, and a shoulder 62 is provided on the collet
3 inserts 58A-G, to ensure that the respective screws 33,
4 59 are not broken when the push is applied.

5
6 The hydraulic pressure requirements of the cylinder 2
7 are thus very high, and for many pipes, the piston push
8 provided by the cylinder 2, 45 will be too great.
9 Therefore, there is provided a safety control system,
10 on both the clamp unit 4 to ensure that the pipe is not
11 crushed, and also on the die head piston cylinder 2, to
12 ensure that overpressure is not applied when swaging.
13 An unloading valve is included in the hydraulic fluid
14 control circuit and is arranged to dump overpressure of
15 hydraulic fluid back into the hydraulic fluid
16 reservoir. The unloading valve is actuated by the
17 electronic circuit. Before swaging a pipe, the
18 operator of the apparatus looks up the characteristics
19 of the pipe in a manual provided with the apparatus,
20 where the characteristics are typically weight or wall
21 thickness, the grade of metal used in the pipe, and the
22 outside diameter of the pipe. The manual then informs
23 the operator what the safe pressure or load that the
24 operator can apply to both the clamp unit and the
25 swaging cylinder 2. The operator then inputs this safe
26 pressure or load into the electronic circuit which, if
27 this safe pressure or load is exceeded, the electronic
28 circuit then operates the unloading valve. Operation
29 of the unloading valve however retains the intended
30 safe working pressure or load. A visual indicator may
31 be used in addition, or in the alternative to the
32 electronic circuit, to indicate that the correct
33 pressure has been achieved.

34
35 Modifications and improvements may be incorporated into
36 the embodiment without departing from the scope of the

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18

1 invention.

2

3

4

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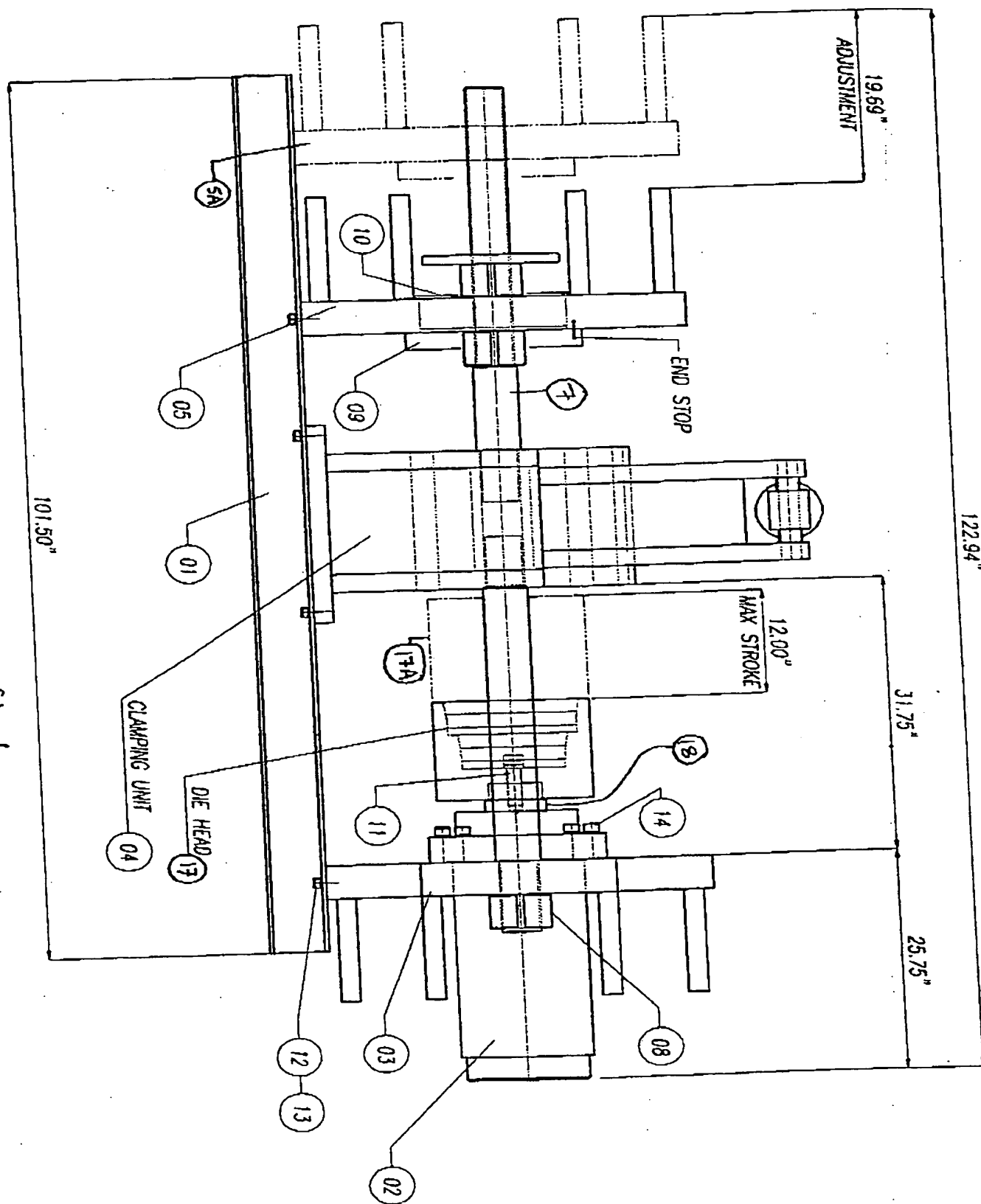
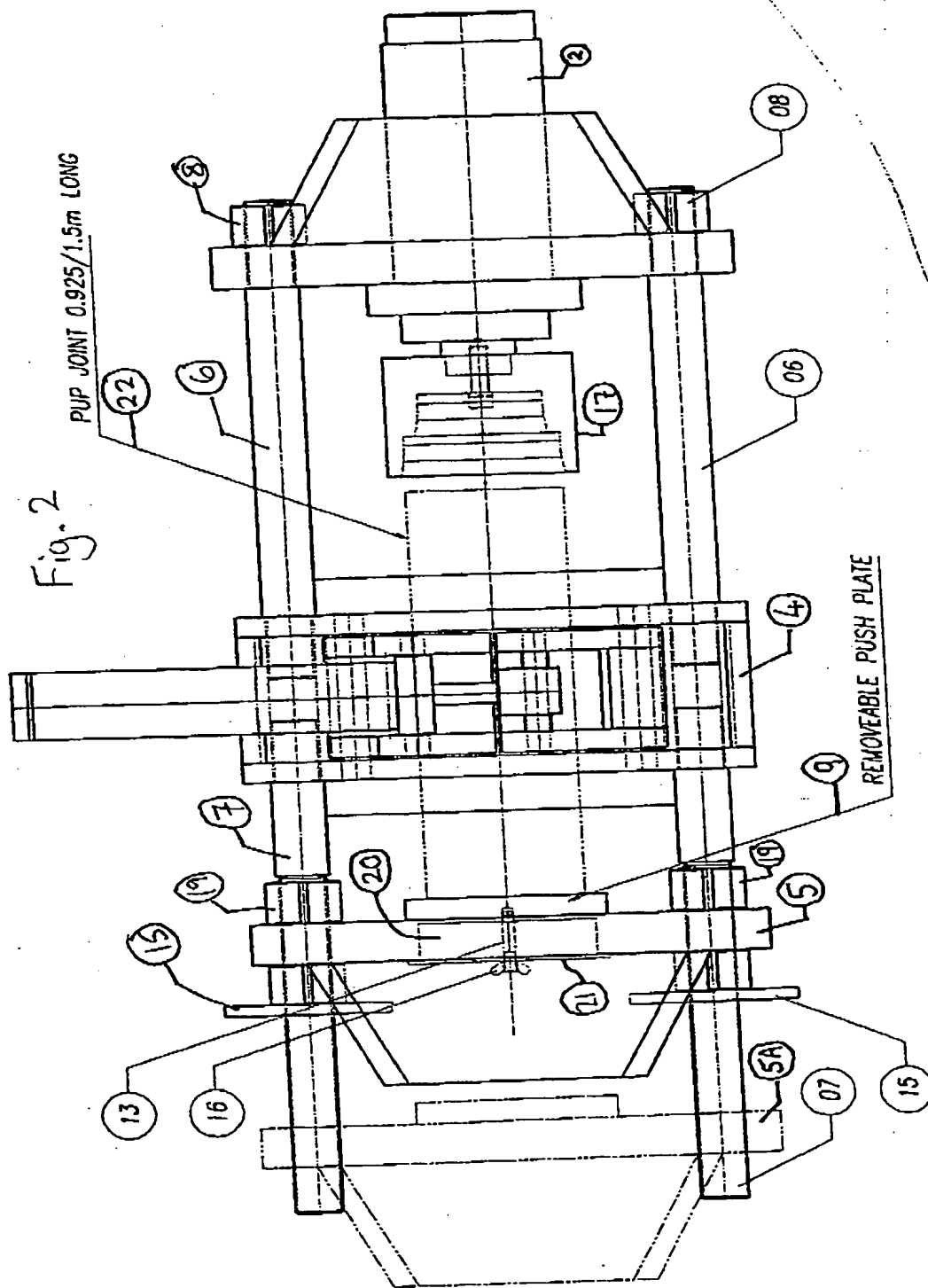


Fig. 1

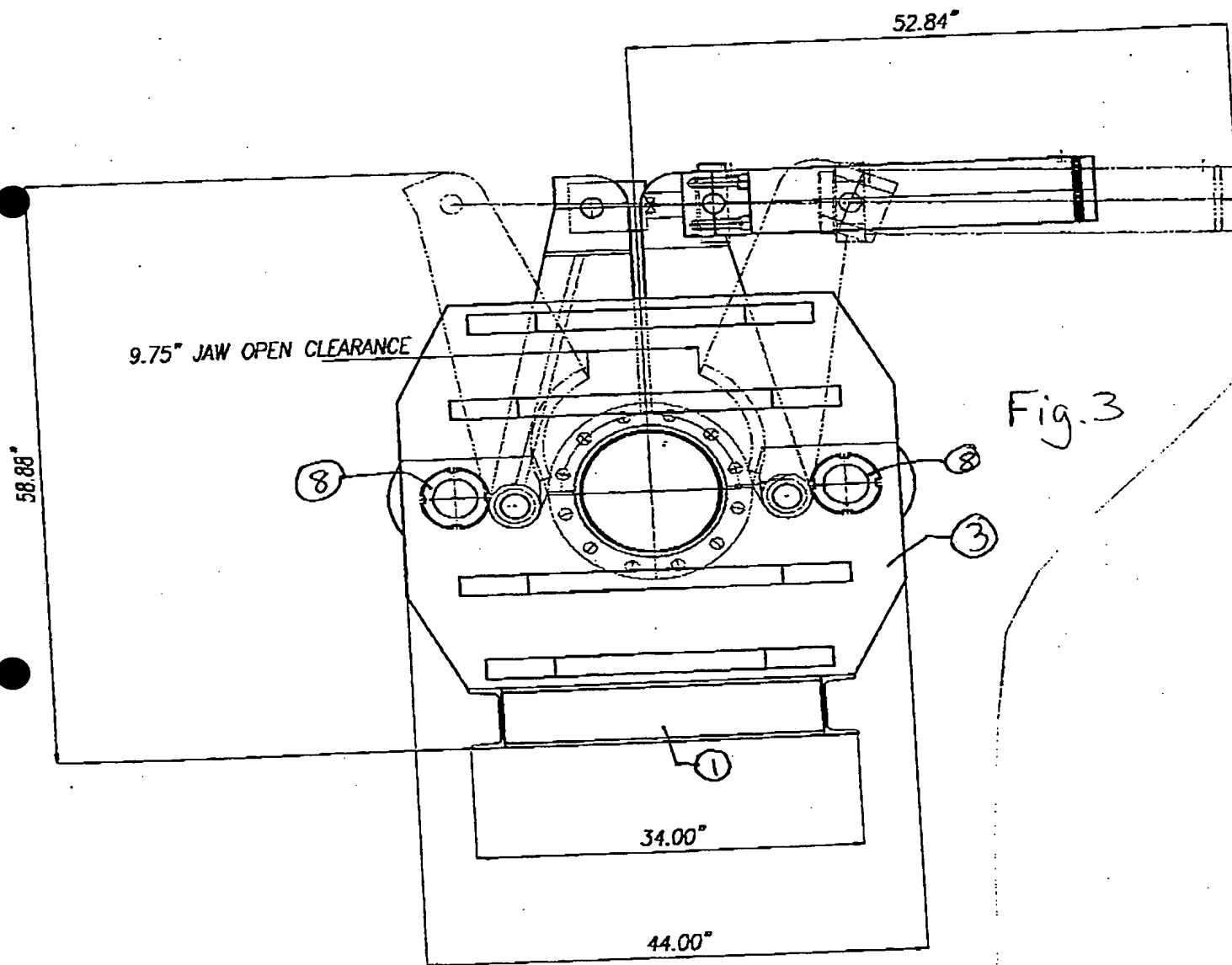
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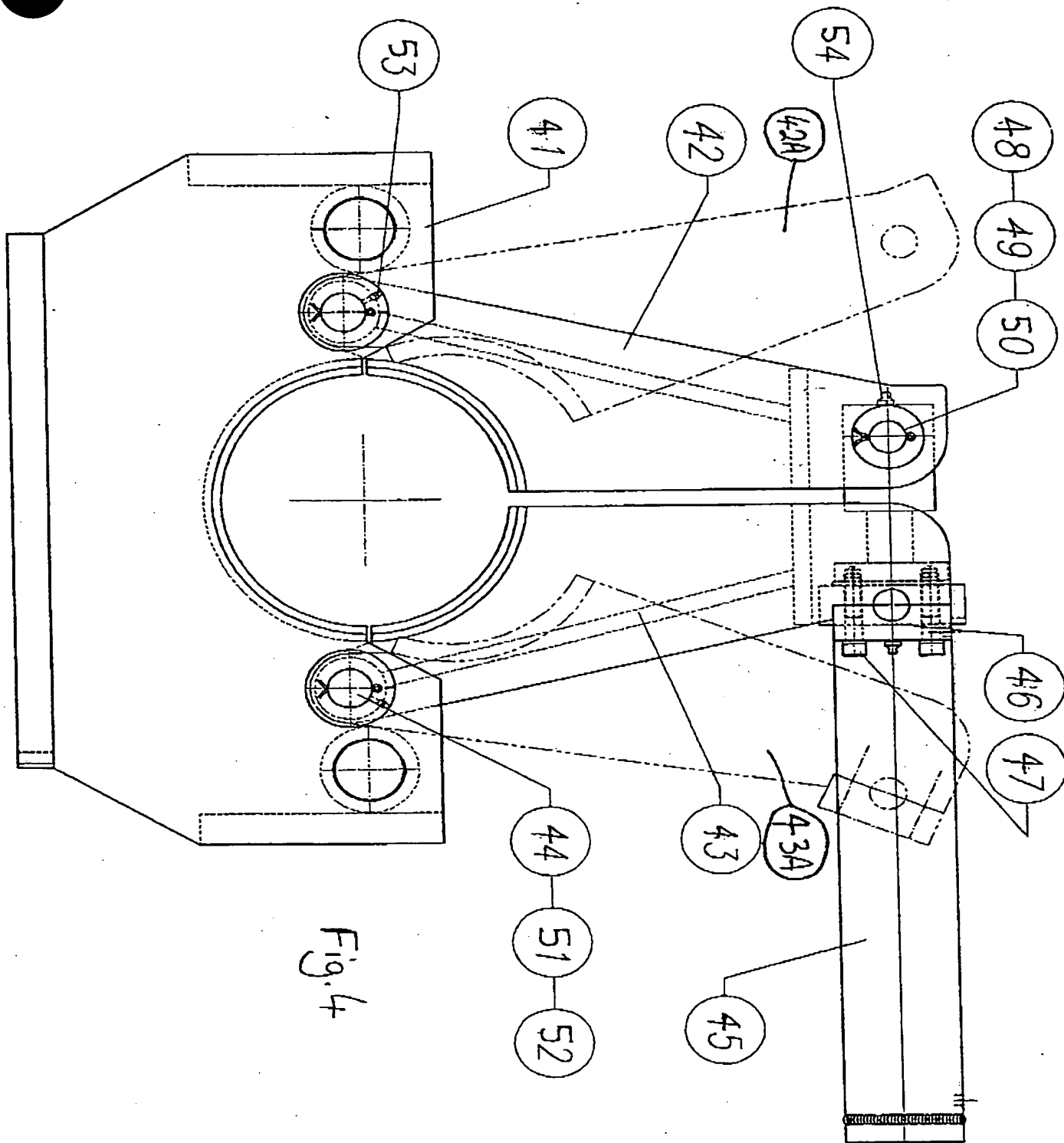
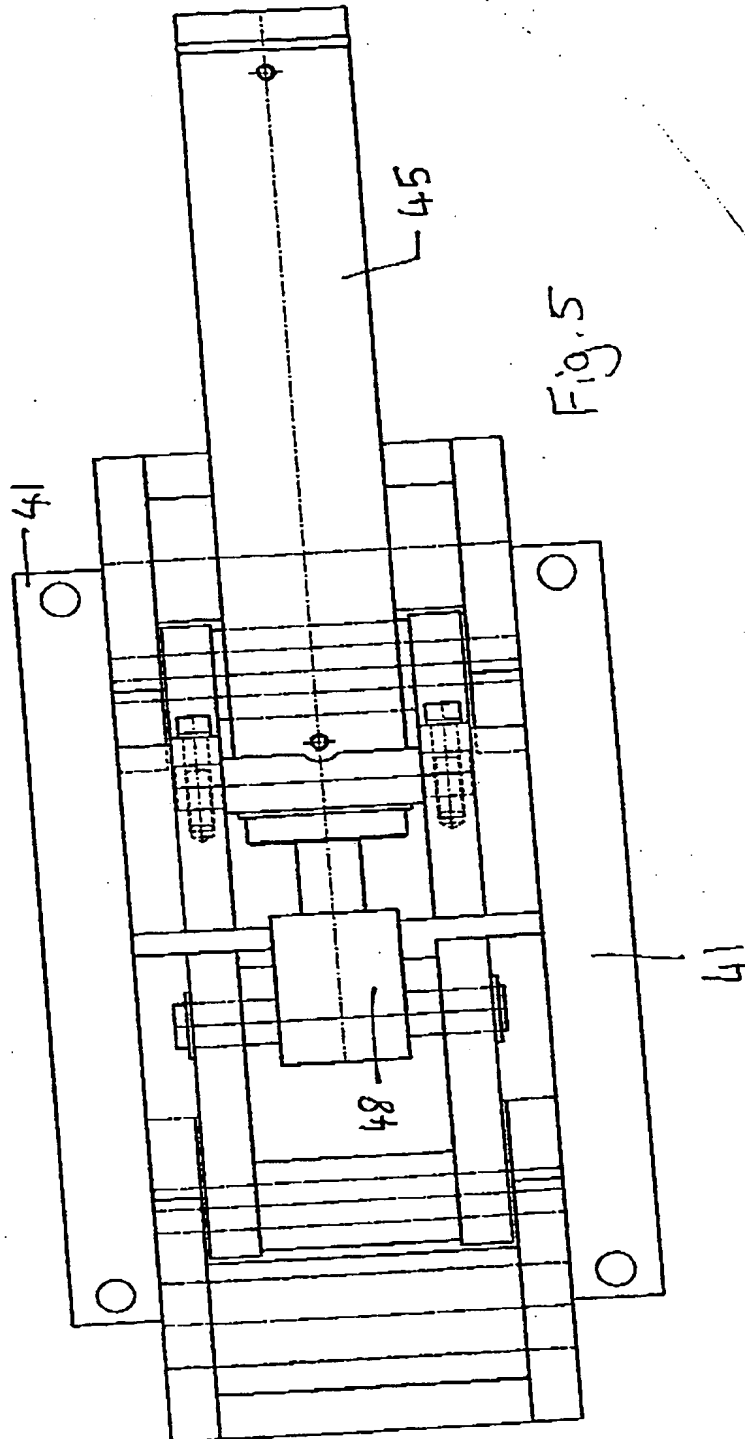


Fig. 4

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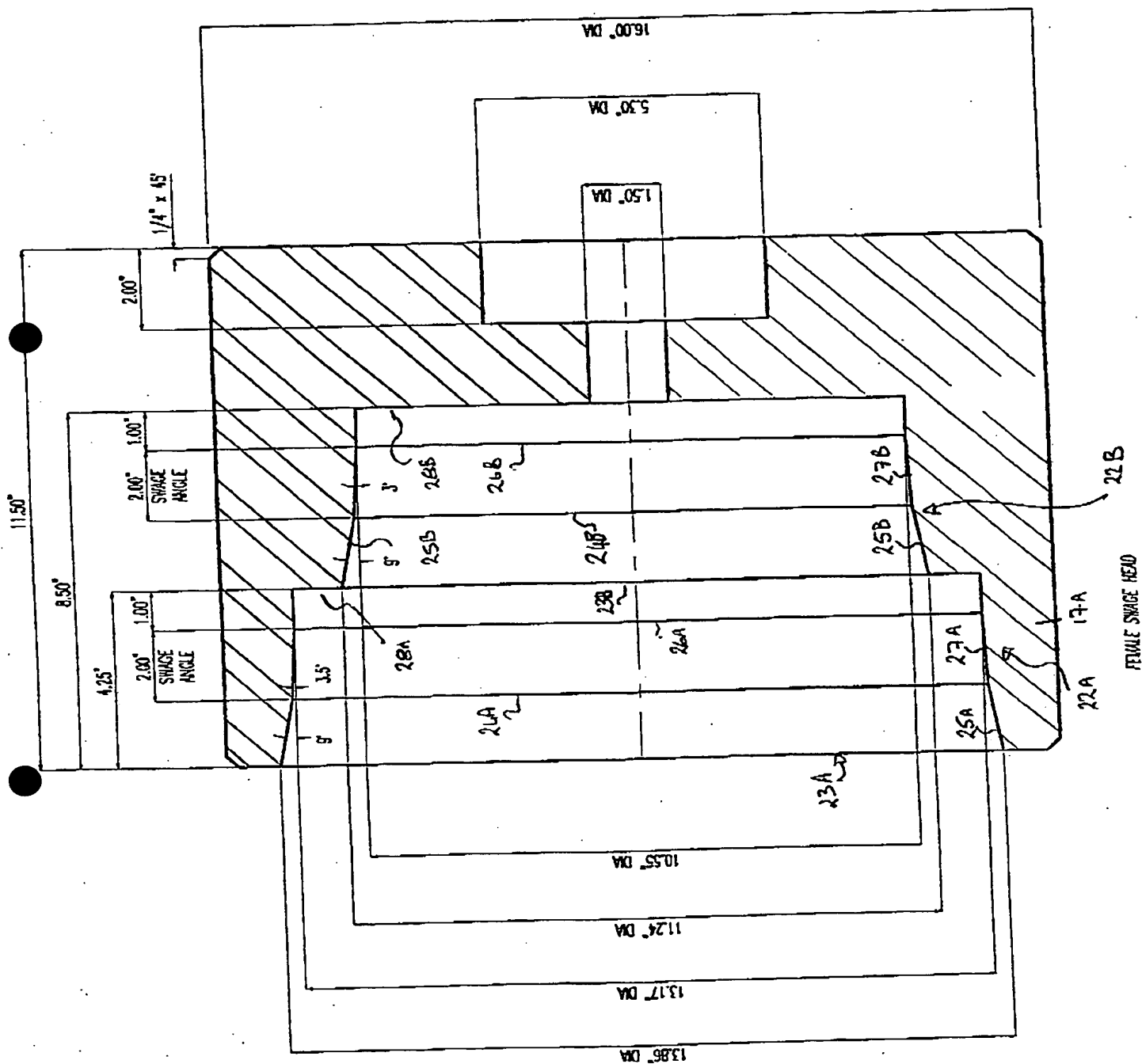
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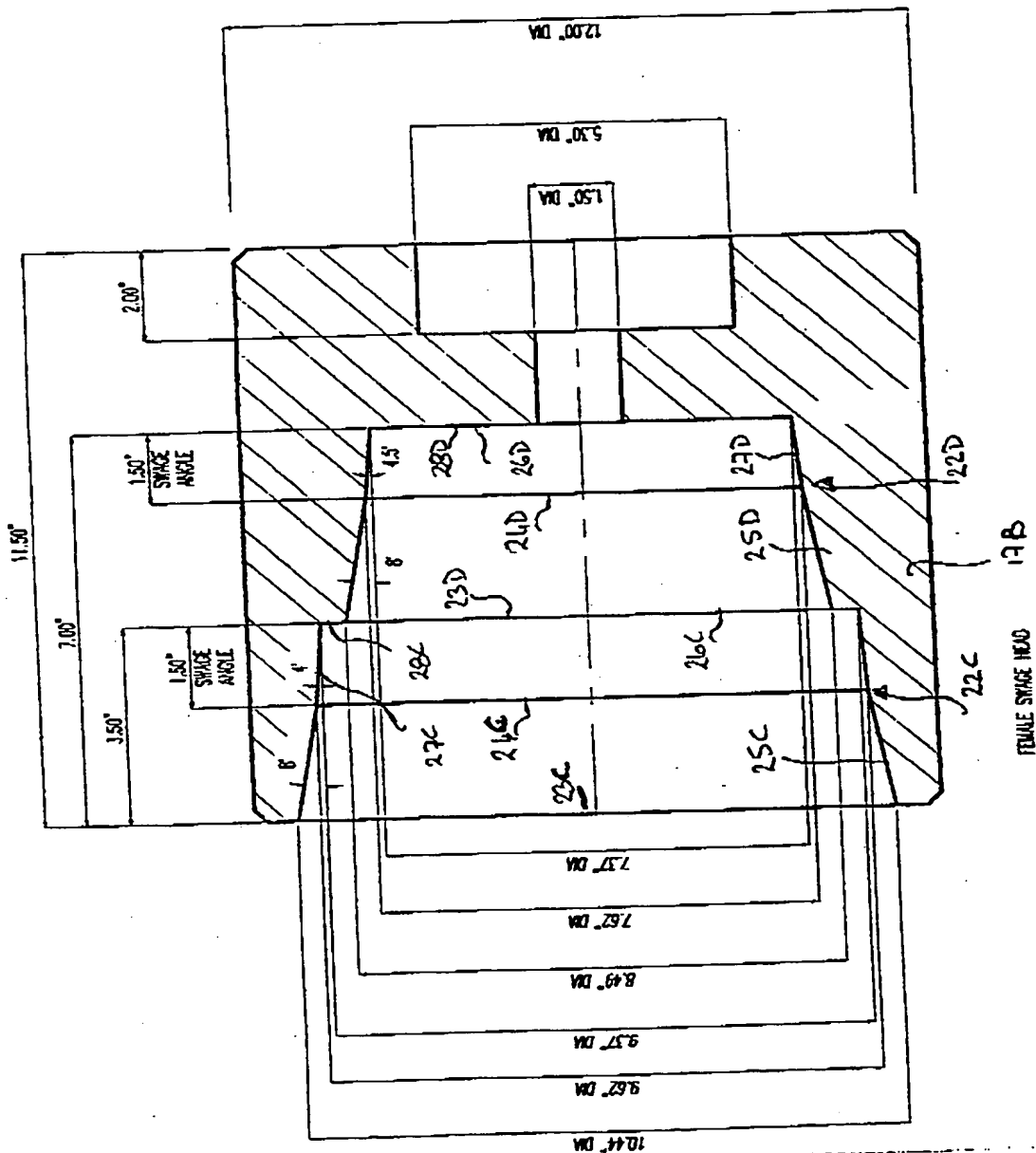


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Fig 7.



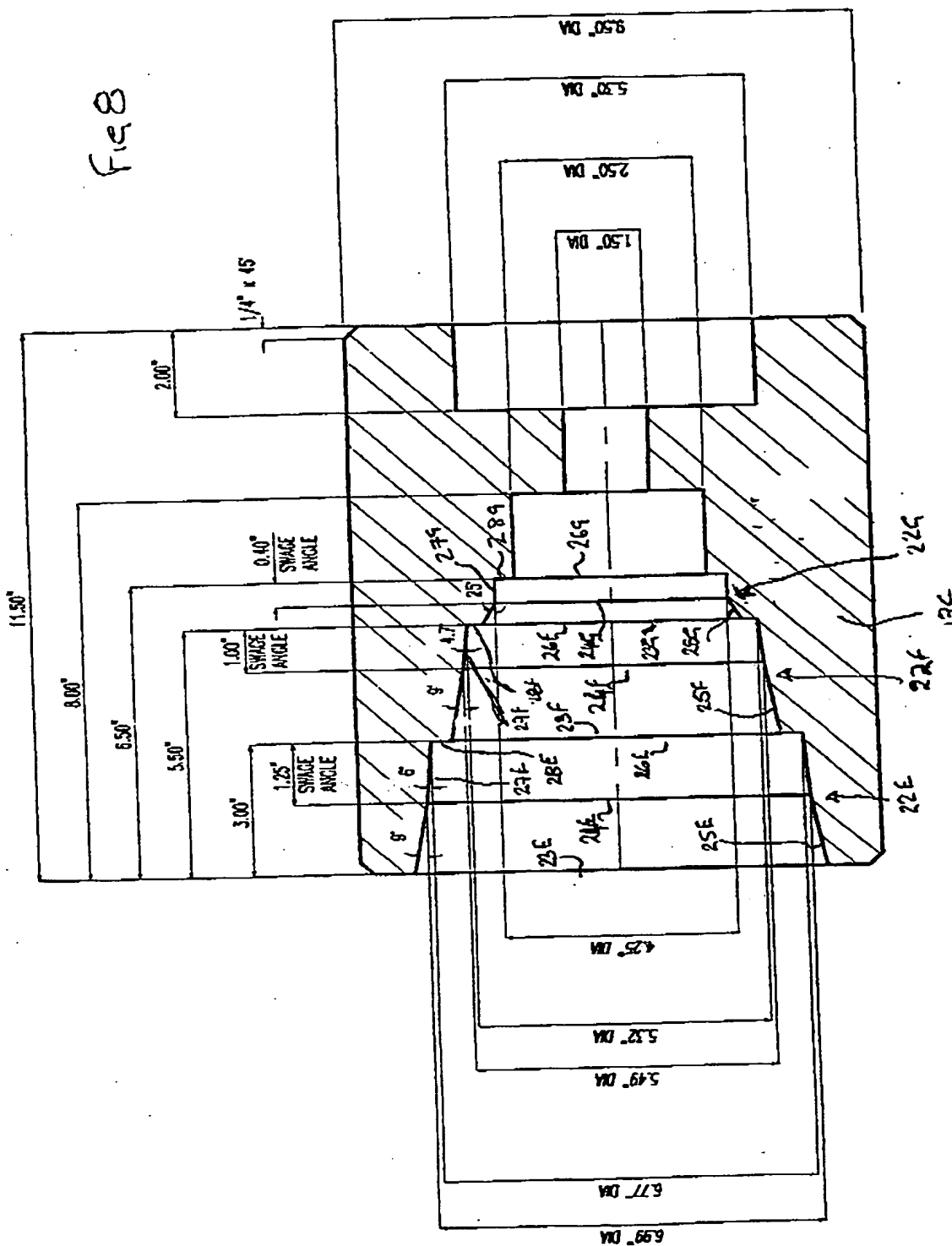
STAMP DETAILS

PIPE SIZE 9.625"/7.625"

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Fig 8



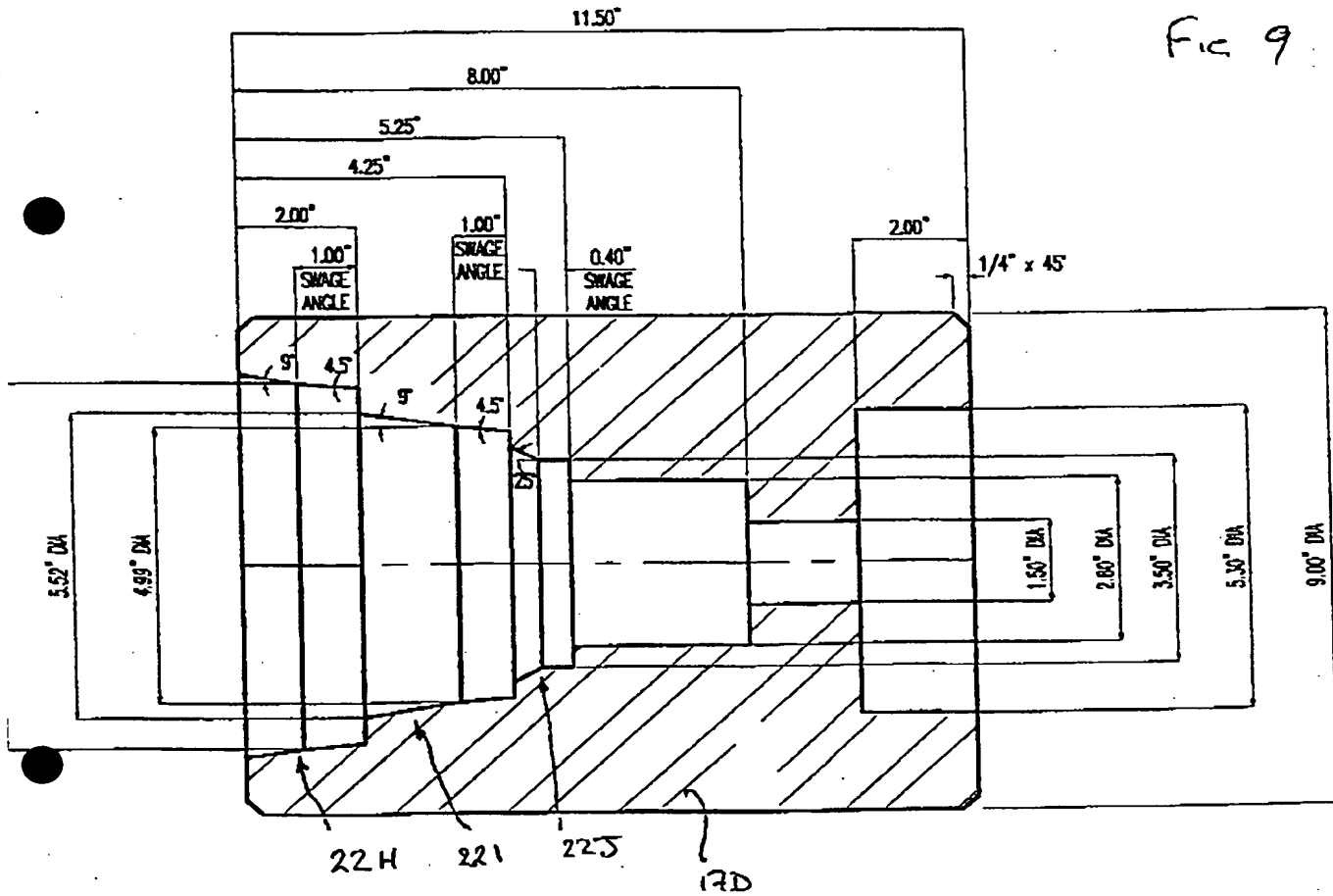
FEMALE SWAGE HEAD

FEMALE HEAD 6 1/2" - 5 1/2" - 7"

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Fig 9



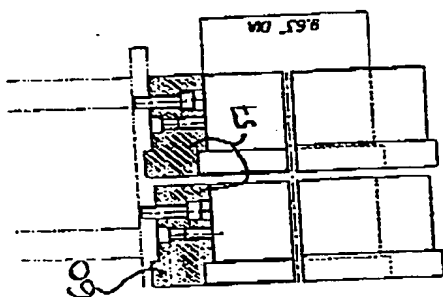
FEMALE SWAGE HEAD

STAMP DETAILS-- PIPE SIZE 4" - 5" - 6 5/8"

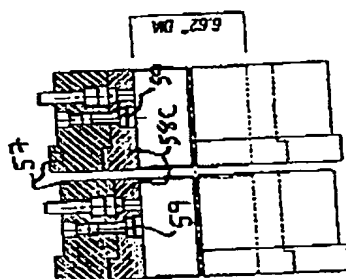
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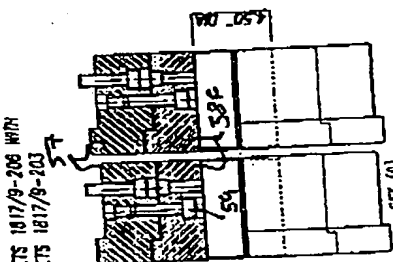
QTY	FIXING SCREW DETAILS
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8	420 x 50mm LONG SOCKET HEAD CAP SCREW
8	420 x 50mm LONG LOW HEAD SKT HEAD CAP SCREW
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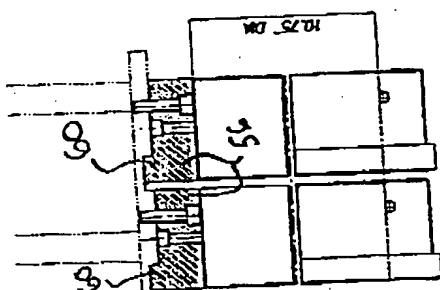
SET (3)
GRIPPER COLLETS 1817/9-203



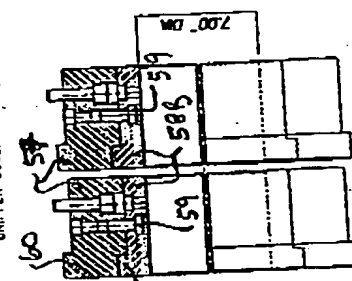
SET (6)
COLLETS 1817/9-208 WITH
COLLETS 1817/9-203



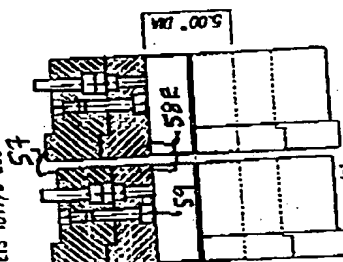
SET (9)
COLLETS 1817/9-208 WITH
COLLETS 1817/9-203



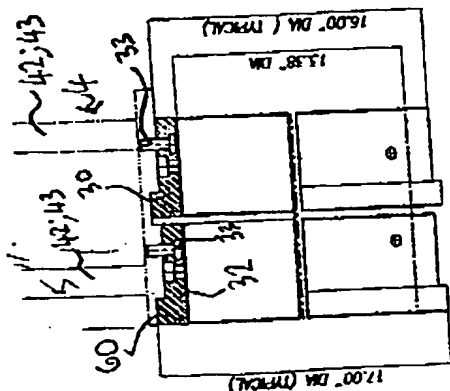
SET (2)
GRIPPER COLLETS 1817/9-202



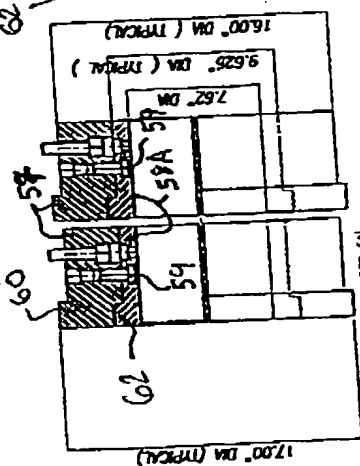
SET (6)
COLLETS 1817/9-205 WITH
COLLETS 1817/9-203



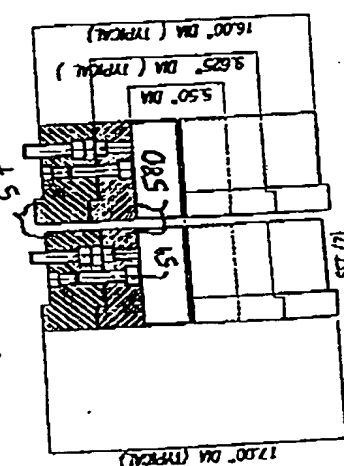
SET (6)
COLLETS 1817/9-208 WITH
COLLETS 1817/9-203



SET (1)
GRIPPER COLLETS 1817/9-201

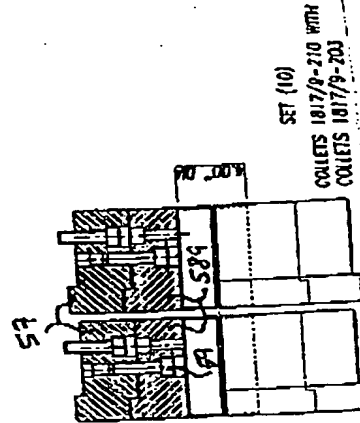


SET (4)
COLLETS 1817/9-204 WITH
COLLETS 1817/9-203



SET (7)
COLLETS 1817/9-207 WITH
COLLETS 1817/9-203

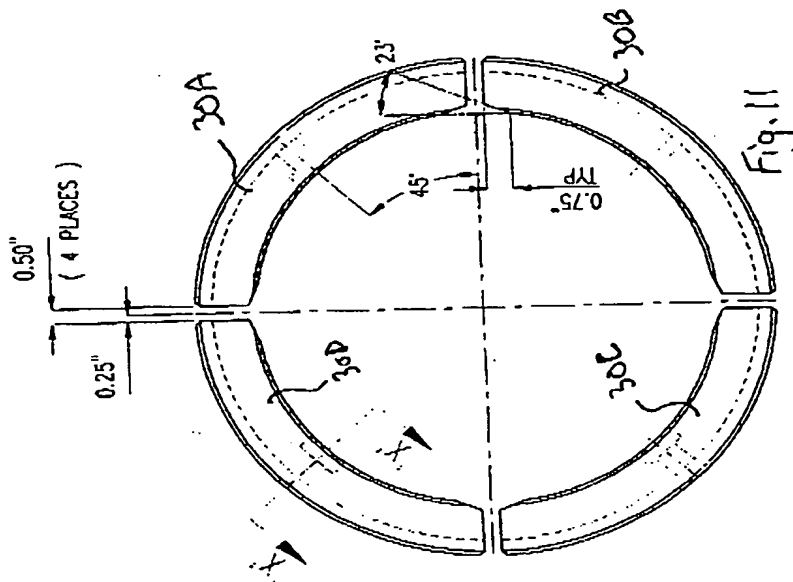
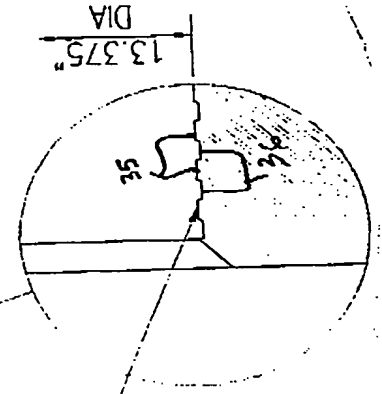
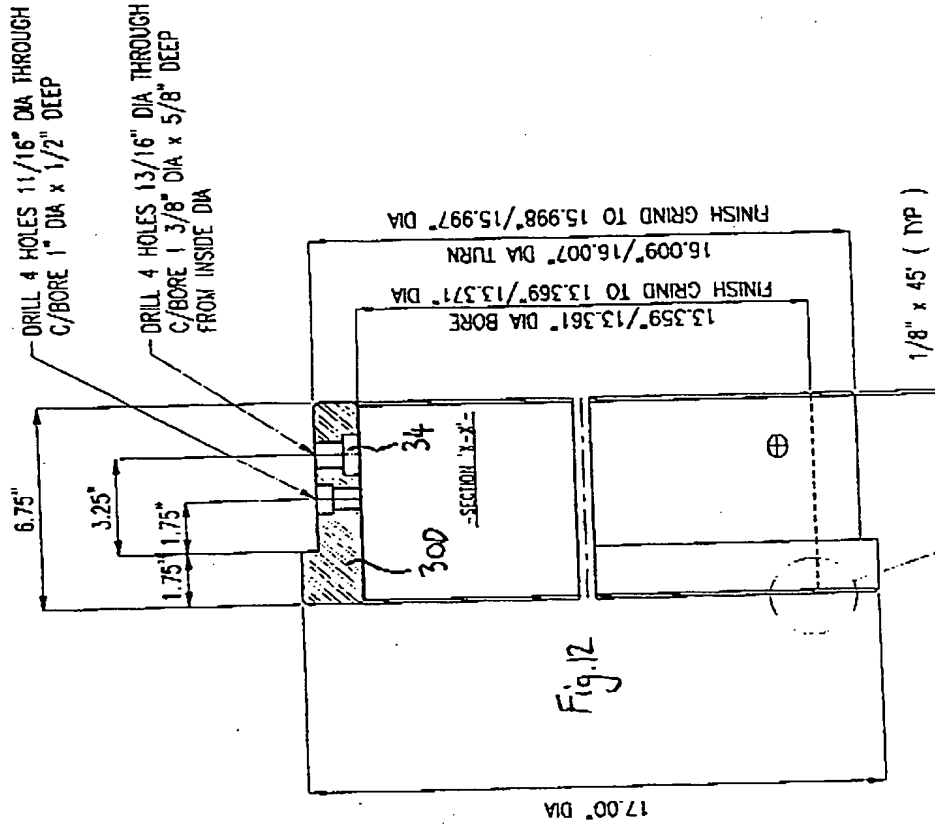
Fig.10



SET (10)
COLLETS 1817/9-210 WITH
COLLETS 1817/9-203

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GRIND AFTER HEAT TREATMENT

2 SETS REQUIRED PER MACHINE

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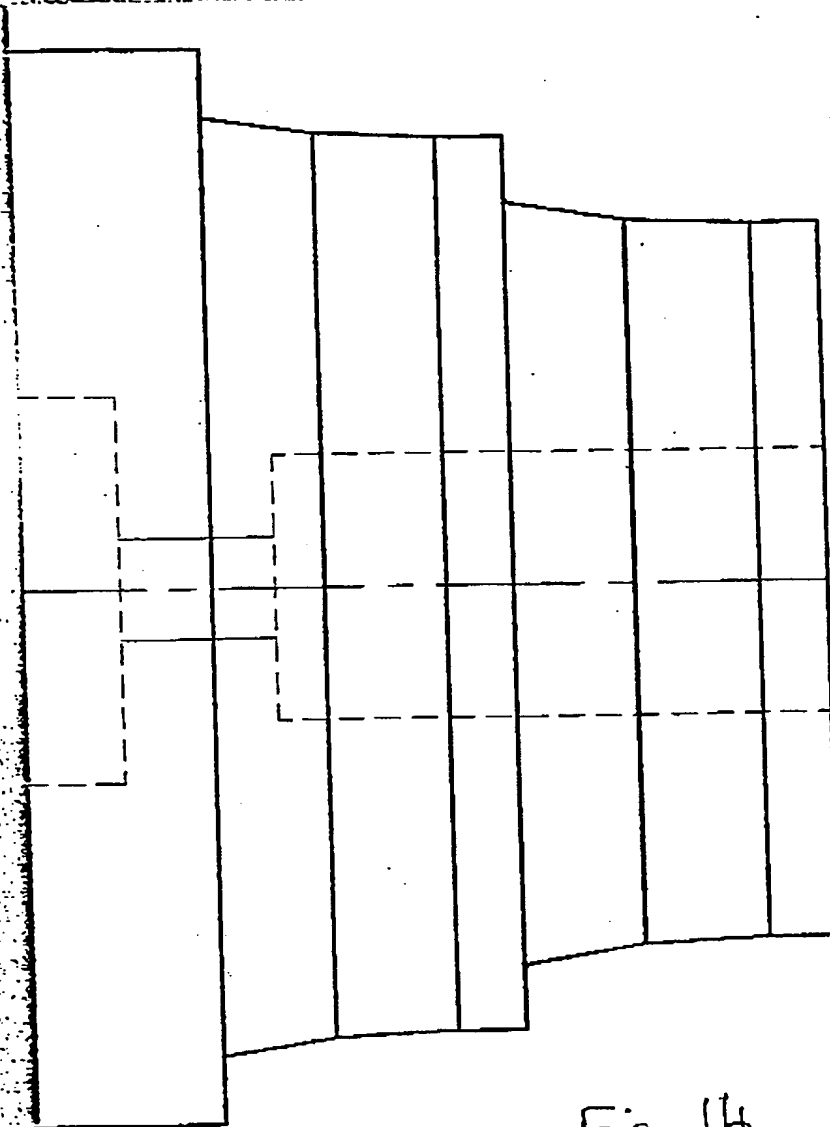


Fig. 14

MALE SWAGE HEAD

 $13\frac{7}{8}'' - 10\frac{3}{4}''$

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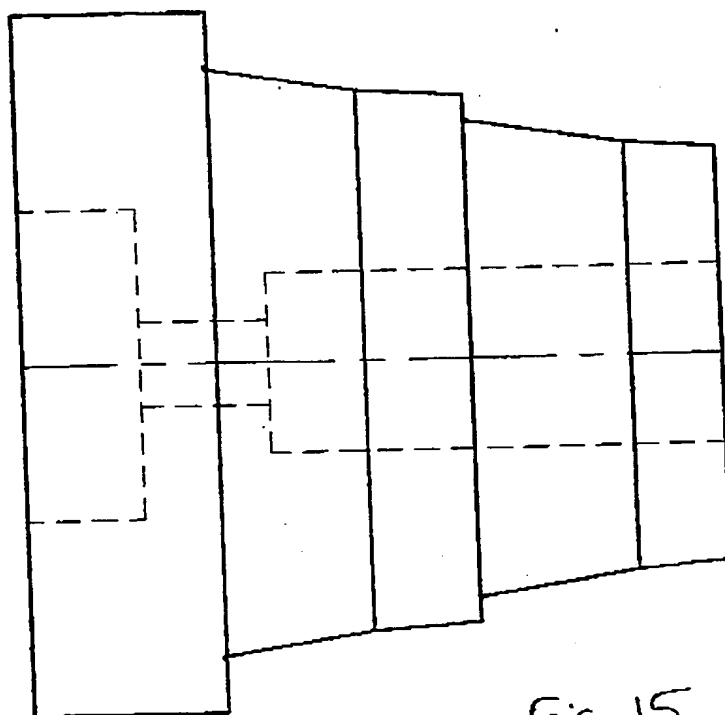


Fig. 15

MALE SWAGE HEAD

$9\frac{5}{8}$ " . $7\frac{5}{8}$ "

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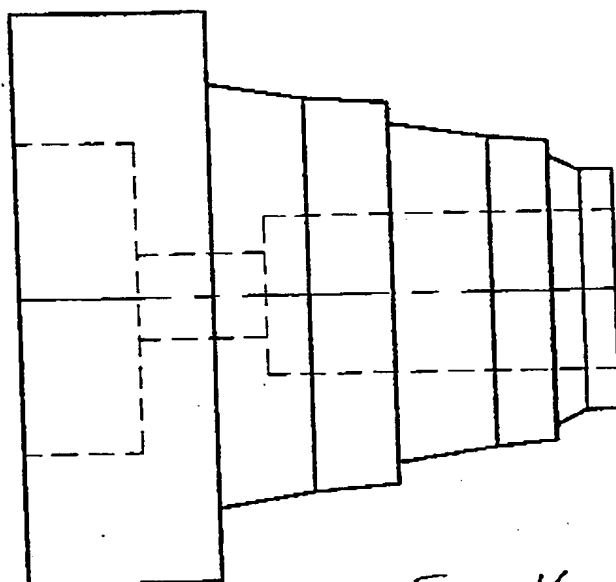


Fig. 16

MALE SWAGE HEAD

4" ~ 5" - 7"

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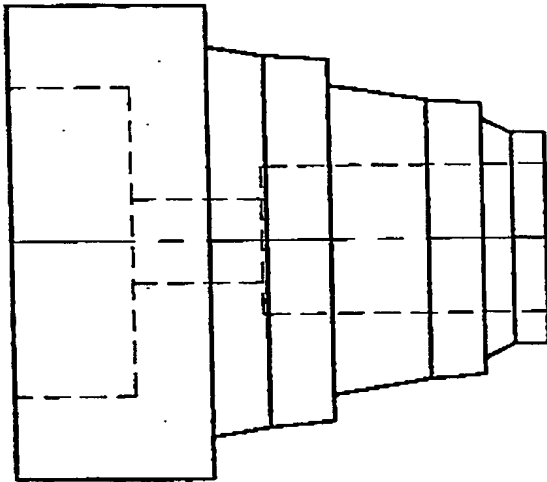


Fig.17

MALE SHANK HEAD

4" - 5" - 6 3/8"

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